

Work Order ID 147092

147092

Page 1

Tuesday, May 31, 2016 1:51:17 PM

Item ID: D4853-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Top Bracket (Replaces P/N G13013-9)
 Start Date: 5/31/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 6/10/2016 Req'd Qty: 12.00 ***12*** Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4853	A

100		0.00							
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100 (14) ϕ 05/16/2016

Waterjet Memo 0.32

FLOW CNC Waterjet ***SMOOTH CUT***

CUT AS PER FILE

DWG REV: A

PROG REV: A

DEBURR

105	QC2- Inspect parts off machine FAI/FAIB	0.00							
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105 (14) ϕ 05/16/2016

QC Memo 0.02

Quality Control

Work Order ID 147092

Tuesday, May 31, 2016 1:51:17 PM

147092

Page 3

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 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.02							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.02							
Quality Control									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating									

14 *Cj* 66-06-18

14 *φ* 1606-20 *DS* 34 9-89

START: 11:30
 OV.T: 3:20
 FINISH: 12:00

14 *φ* 1606-20 *DS* 34 9-89

Work Order ID 147092

Tuesday, May 31, 2016 1:51:17 PM

147092

Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.02							
Quality Control									
180	Identify as per dwg & Stock Location: 5A	0.00							
180									
Packaging	AND IDENTIFY USING A FINE	0.02							
Packaging	POINT PERMANENT MARKER								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.20							
Quality Control									

JUN 20 2016

JUN 22 2016

JUN 22 2016

JUN 22 2016

Picklist Print

Tuesday, May 31, 2016 1:51:16 PM

Page 1

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147092

Parent Item: D4853-7

D4853-7

Parent Item Name: Top Bracket (Replaces P/N G13013-9)

Start Date: 5/31/2016

Required Date: 6/10/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No				f	13.9945		5.254737			

~~*M6061T6B0.750X01.500*~~

**

De 16/06/16

6061-T6 Bar .750 X 1.50

W/A

AK

Location	Loc Qty	Loc Code
MAT	13.9945	
134284	4.817	
m131700	2.7905	
m132876	0.25	
m134377	6.137	

M6061T6 B .750 X 2.00

B: 133038

4.4

DART AEROSPACE LTD		Work Order: 147 092
Description: Top Bracket		Part Number: D 4853-7
Inspection Dwg: D4853 Rev: A		Page 1 of 1

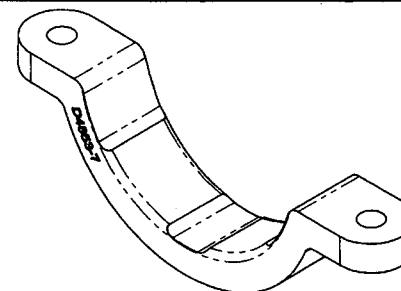
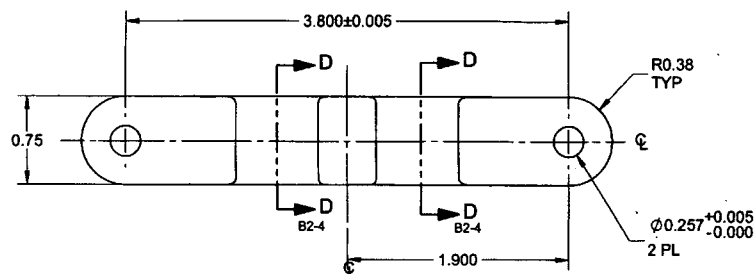
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<i>Waterjet</i>						
Ø 0.75	± 0.030	0.746	✓		vern	JCL-08
Ø 0.30	± 0.030	0.301	✓		↓	
Ø 0.50	± 0.030	0.500	✓			
Ø 0.25	± 0.030	0.25	✓		H.G.	31006
R 1.25	± 0.030	1.250	✓		Plug	
R 0.13	± 0.030	0.125	✓		Rad. Gauge	
<i>Manual Milling</i>						
Ø 0.257	± 0.005	0.257	✓		vern	JCL-08
3.800	± 0.005	3.800	✓		"	
R 0.38	± 0.03	0.375	✓		Rad. Gauge	
R 0.06	± 0.040	0.060	✓		"	
4.55	± 0.030	4.550	✓			

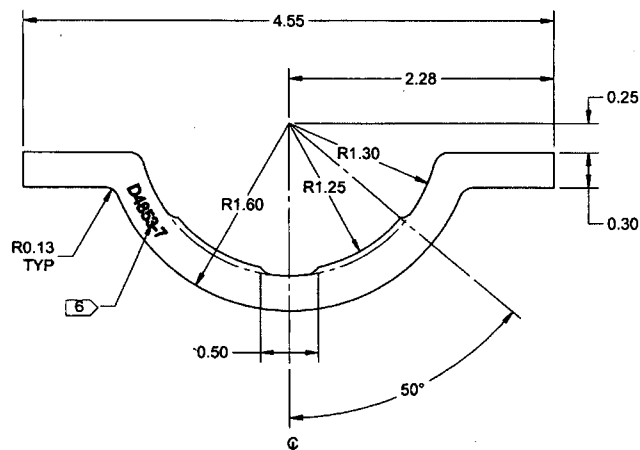
Measured by: 32 9-89	Checked by: <i>H.</i> DAS 08 9-89	QC Inspector:
Date: 16-06-10	Date: 16/06/14	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



aluminum



SECTION D-D
SCALE 2X

D6-4

R0.06 MIN - R0.10 MAX
2 PL

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.12 lbs
- 8) REPLACES GENEVA P/N G13013-9

D4853-7 TOP BRACKET

RELEASED
2013-07-16

DESIGN	OS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	OS		
CHECKED	PC	DRAWING NO.	REV. A
MFG. APPR.	27	D4853	SHEET 4 OF 4
APPROVED	27	TITLE	SCALE
DE APPR.	27	TOP BRACKET	NTS
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